Work Order ID 68468 Page 1 Wednesday, April 13, 2011 4:15:39 PM D3454-5 Item ID: Accept Setup Start **Revision ID:** Stop Bushing Item Name: **Start Date:** 4/13/2011 Start Qty: 20.00 **Cust Item ID:** Required Date: 4/20/2011 Reg'd Oty: 20.00 **Customer:** Reference: Start Run Date: /// **Tooling: Approvals:** Date: Stop QC: Date: SPC (Y/N): Date: Reject Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Insp. Work Center ID **Description** Qty Qty Number Stamp Code **Run Hours Draw Nbr Revision Nbr** D3454 Rev B 100 0.00 Hardinge CNC LATHE SMALL 2011.5.16 0.00 Hardinge Memo Hardinge CNC Lathe Small 1-TURN AS PER FOLIO FA572 & DWG D3454, JFOLIO REV: DWG REV: 2-DEBURR AS REQUIRED 110 QC2- Inspect parts off machine FAI/FAIB 0.00 21-8-13 0.00 Memo Quality Control

120

QC8- Inspect parts - second check

0.00

SL 1105/17

Quality Control

Memo

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PROCEDURE CHANGE					Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
										·
Part No	:	PAR #:	Fault Cat	NCR: Yes No DQA: Date:						
Resolution:		esolution:	Disposition: QA			Clos	sed:		Date: _	
NCR:			VORK ORI	DER NON-CONFORMA	ANCE (N	CR)				
DATE	STEP	Description of NC	Corrective Action Section B			Sign & Verific		cation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Secti	on C	Chief Eng	QC Inspector

Page 2

Item ID:

D3454-5

Wednesday, April 13, 2011 4:15:39 PM

Accept

Setup Start

Stop



**Revision ID:** 

**Start Date:** 

Bushing Item Name:

4/13/2011

Start Qty: 20.00

Required Date: 4/20/2011 Req'd Qty: 20.00



**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Start

Run

Qty

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID

130

Small Fab

Small Fab

Small Fab

Operation

Description

Memo Deburr if hecessarv.

Memo

Set Up/ **Run Hours** 

0.00

11.5.17

Tool # Plan

Code

Qty 2

Accept

Reject Reject Number

Insp. Stamp

140



Quality Control

QC5- Inspect part completeness to step on W/O

150

Packaging

Packaging

Identify as per dwg & Stock Location: 6

0.00

0.00

Memo

	-										
W/O:			W	ORK ORDER CHANG	GES						
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	I	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
				·							
		PAR #:	Fault Cate	egory:	NCR: Yes No DQ				)A: Date:		
Resolution:		esolution:	Disposition: Q			Clos	ed:		Date: _		
NCR:			WORK ORD	ER NON-CONFORM	ANCE (N	CR)					
DATE	STEP	Description of NC	Corrective Action Section					cation Approval		Approval	
	SILI	Section A	Initial Chief Eng	Action Description Chief Eng			Section C		Chief Eng	QC Inspector	
						1					

#### Work Order ID 68468

Wednesday, April 13, 2011 4:15:39 PM



Page 3

Item ID:

D3454-5

Accept



Setup Start

Stop

Start



**Revision ID:** 

Item Name: **Start Date:** 

Bushing

4/13/2011

**Start Qty: 20.00** 

Req'd Qty: 20.00



**Cust Item ID:** 

**Customer:** 

Reference:

Α	nn	rov	/8	s:

Process Plan:

Date:

**Tooling:** 

Date:

Run



Approvais:

QC:

Required Date: 4/20/2011

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/

Work Center ID

Description

Operation

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** 

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Number Stamp

Insp.

Quality Control

160

Memo

W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRC	PROCEDURE CHANGE				Approval Chief Eng / Prod Mgr	Approval QC Inspector		
							, , , , , , , , , , , , , , , , , , ,			
		·								
Part No	•	PAR #:	Fault Cat	egory:	NCR: Yes	No DQA:	Date: _			
	R	esolution:	Dispositi	on:	_ QA: N/C Cld	QA: N/C Closed: Date:				
NCR:		1	WORK OR	DER NON-CONFORMA	NCE (NCR	)				
DATE	CTED	Description of NC		Corrective Action Secti		Verification	Approval	Approval		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector		
				-						

### **Picklist Print**

Wednesday, April 13, 2011 4:15:44 PM

Work Order ID: 68468

Parent Item: D3454-5

Parent Item Name: Bushing

Start Date: 4/13/2011

Required Date: 4/20/2011

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV. A 05.11.17

New Issue

EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750	,	Purchased	No			100	f	114.0500	0.0375	0.789474			
										<b>&gt;</b>	11.0	10	

303 Round Bar 0.750

Location MAT028

117142

117328

**Loc Oty** 114.05

54.05

60

Loc Code

W/O:			ORK ORDER CHANG	ES						
DATE	STEP	PRO	CEDURE CH	URE CHANGE			Date (	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
	·									
		e e e e e e e e e e e e e e e e e e e								
Part No	:	PAR #:	Fault Ca	tegory:	_ NCR: Ye	s No	DQA:		Date:	
	R	esolution:	Disposit	_ QA: N/C	Close	ed:		Date: _		
NCR:		V	VORK OR	DER NON-CONFORMA	ANCE (N	CR)				
DATE	CTED	Description of NC Corrective Action			ion B	Verificat	ion	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		n & ite	Section		Chief Eng	QC Inspector
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DART AEROSPACE LTD	Work Order:	48468
Description: Bushing	Part Number:	D3454-5
Inspection Dwg: D3454 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototype	

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.250	+0.005/-0.000	,250			120,051	
Ø0.372	+0.000/-0.005	, 370				
0.400	+0.005/-0.000	403			. )	
Ø0.75	+0.008/-0.001	750				
0.060	+0.010/-0.000	,750				
				***************************************		
						,
				1		,
						W-8-1-2-7-2-7-2-7-2-7-2-7-2-7-2-7-2-7-2-7-2
		HILLIAN STATE OF THE STATE OF T				
		***************************************		***************************************		·

Measured by:	Audited by:	Prototype Approval:	N/A
Date: 1(	Date: 11/05/17	Date:	N/A

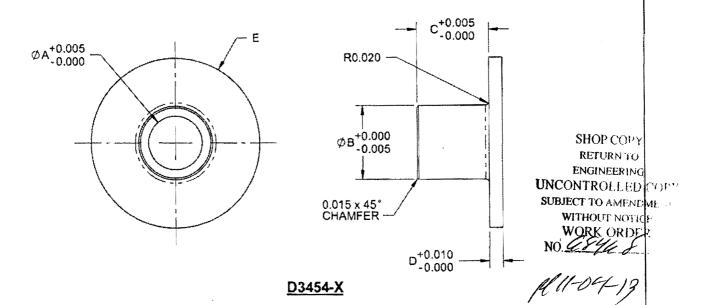
Rev	Date	Change	Revised by	Approved
Α	06.09.01	New Issue	KJ/JLM	
В	07.01.17	0.60 dimension removed	KJ/JLM	1
С	07.09.06	0.060 dimension added	KJ/JLM , A	
D	09.05.04	Tolerance for 0.060 revised	KJ/DD	Jull
	, ,_		177	77

W/O:		WORK ORDER CHANGES											
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
	•							1					
Part No	:	PAR #:	_ Fault Ca	tegory:	NCR	NCR: Yes No DQA: Date:							
	R	esolution:	Disposit	ion:	QA: N/C Closed: Date:								
NCR:		W	ORK OR	DER NON-CONFORM	ANCE	(NCR	)						
DATE	STEP	Description of NC	Corrective Action Section B			O: A		cation	Approval	Approval			
	O,L.	Section A	Initial Chief Eng	Action Description Chief Eng				ion C	Chief Eng	QC Inspector			
									,				



DESIGN RF		DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECK	ED	APPROVED #	DRAWING NO.	REV. B SHEET 1 OF 1		
DATE		J	TITLE	SCALE		
05.12.05			BUSHING	2:1		
 Α	05.09.02		NEW ISSUE			
В	0	5.12.05	REVISE -5/-7			

RELEASED 05.12.09



#### 1) SPECIFICATION: D3454-X BUSHING

DASH No.

#### WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)	D (in)	E (ìn)
-1	0.316	0.435	0.420	0.060	1.00
-3	0.316	0.435	0.400	0.060	0.75
-5	0.250	0.372	0.400	0.060	0.75
-7	0.250	0.372	0.343	0.060	0.75



#### NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF. DART SPEC. M303R)
  2) FINISH: NONE
  3) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  5) ALL DIMENSIONS ARE IN INCHES
  6) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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W/O:			WC	ORK ORDER CHANG	ES			***************************************	
DATE	STEP	PROCEDURE CHANGE				Date C	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
							7 100 mgi		
				***************************************					
		*							
Part No	•	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQA:	Date: _		
	R	esolution:	n: Disposition:			osed:	Date: _	Date:	
NCR:		·	WORK ORD	ER NON-CONFORM	ANCE (NCF	R)			
DATE	STEP	Description of NC Section A	•	Corrective Action Section B			ion Approval	Approval	
DAIE	SIEP		Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Section	C Chief Eng	QC Inspector	
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